



/// .005 A  
[.003]

\*  
3.500 [88.90]  
ULTRA - HIGH VACUUM  
TIGHT EXPLOSIVE BONDING  
(FULL LENGTH ULTRA SONIC TEST NEEDED)

-A-  
[.003]

MAT'L. STAINLESS STEEL

STAMP 1/4" HIGH THE LETTER "A"  
ON THIS SURFACE

/// .005 C

MAT'L. GLID-COP

MAT'L. STAINLESS STEEL

2X .250 [6.35] BEFORE  
EXPLOSIVE BONDING

\*  
+.020 [0.51]  
2X .197 [5.00] [0.00]

-C-  
[.003] A

#### NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:  
A) CIMCOOL 5 STAR 49  
B) TRIM SOL
3. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
4. CERTIFICATION OF ULTRA SONIC TEST AND VACUUM EXAMINATION SHALL BE SIGNED BY A CONTRACTOR REPRESENTATIVE AUTHORIZED TO SIGN SUCH CERTIFICATION
5. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY

\* MACHINE AFTER EXPLOSIVE BONDING

3	4.000 [101.60] WAS 4.500 [114.30]	M.J.M.	J.C.	1/6/99
2	4.250 [107.95] WAS 3.750 [95.25]			
	1.750 [44.45] DIM. ADDED	M.J.M.	J.C.	6/18/98
1	NO CHANGE, NO DRAWING	M.J.M.		
SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED, TOLERANCES ARE IN INCHES		THIS DRAWING IS THE PROPERTY OF		
TOLERANCES		ARGONNE NATIONAL LABORATORY		
DECIMALS		M1410001-03-1		
FRACTIONS		DRAWN BY		
ANGLES		MUSCIA		
SURFACE FINISH		DATE		
REMOVE ALL BURRS AND BREAK SHARP EDGES TO MAX.		2/9/98		
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST AMS 2629		D. SHU		
SURFACE FINISH TO BE IN ACCORDANCE WITH LATEST AMS 2629		DATE		
NO NET SCALE DRAWING		3/19/98		
		J. CHANG		
		DATE		
		2/998		
		SHU/MUSCIA		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		
		D. SHU		
		DATE		
		3/20/98		